

Patent Abstracts of Japan

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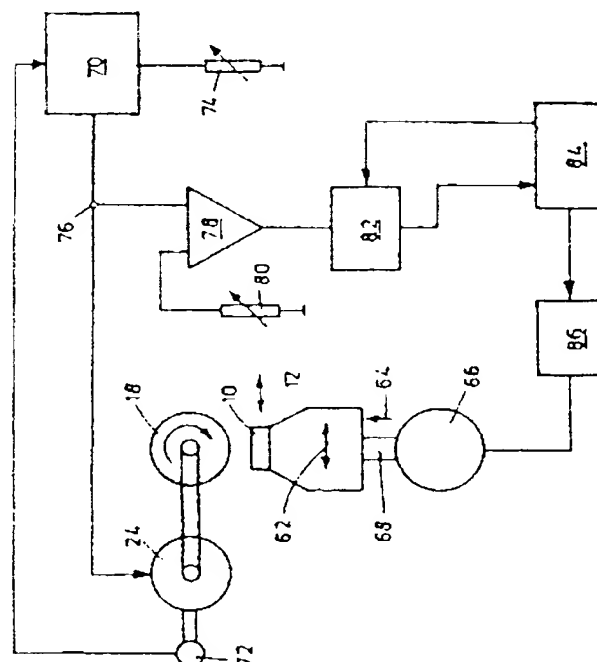
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TITLE : METHOD AND DEVICE FOR
 CONTROLLING POSITIONING AND
 CONTACT MOTIONS OF GRINDING
 DISC



ABSTRACT : PURPOSE: To accurately feed after grinding by measuring the value changing corresponding to the friction moment applied to a grinding disc and stopping the touch-on motion at a point of time sequence of measurement values all reach a specified limiting value corresponding to the specified maximum value of friction moment.

CONSTITUTION: A current value of a driving motor 24 of a control tool 18 is taken at a branch terminal 76 and sent to a comparator 78 to be compared with a specific limiting value output from another potentiometer 80 therein. During operation, a sequence of measured current values and a controlled and preset limiting value are introduced to a current value storage device 82 and further introduced to an arithmetic device 84. In the arithmetic device 84, according to a control program controlled at every time, for the touch-on motion or the positioning motion, the current value or a difference from the limiting value is counted and synthesized in a regulated manner to output a control command according to the specific program from the arithmetic device 84 to a control circuit 86 of a step motor 66 for feeding a workpiece 10. Accordingly, after grinding, the workpiece 10 can be fed accurately at a correct time.

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